



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



RB6798927-1

Job Sheet 195146



Part No: RB6798927-1

Job Qty: 4 pcs

Part Name: Jaw Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/14/19

Job Tracking No:

Due Date: 7/29/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RB6798927 Rev.2 IPP Rev. A 18.05.29 new issue DP Verify DD

Ship Via:

STOCK (9) RB6798927 IS ACCEPTABLE PBR
BEN 19-752 3122 JULY 2/19

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	7/29/19	7/29/19	0.00	0.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
110	QC 9	4 pcs	7/29/19	7/29/19	0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Outsource - 12 - Black Oxide	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 30		
							QC 5 - 40		
							GROCO2		
							Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
140	Packaging 2-1 - Receive - B4B	4 pcs	7/29/19	7/29/19	0.00	0.00	Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S186996



Part: RB6798927-1

Job No: 195146

Serial No/Batch: S186996

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/04/19

Plex 5/14/19 4:53 PM Dart.Renwick.Jennife

				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUN 11 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150	QC 6	4 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
160	Packaging 3-1 - Stock - B4B	4 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	4 pcs	7/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - Weld per dwg A/R Steel rod Batch: _____ Weld as per DWG. Ensure proper positioning of engraving.
 Descriptions: 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 130 - Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO 43647 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required
 140 - Receive & Inspect for Damage & Mat'l Certs
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock Location: _____
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6798927-1A	Jaw Part	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5089231</u>
RB6798927-1B	Jaw Part	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5093382</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RB6798927-1A	4	4	0
	RB6798927-1B	4	4	0

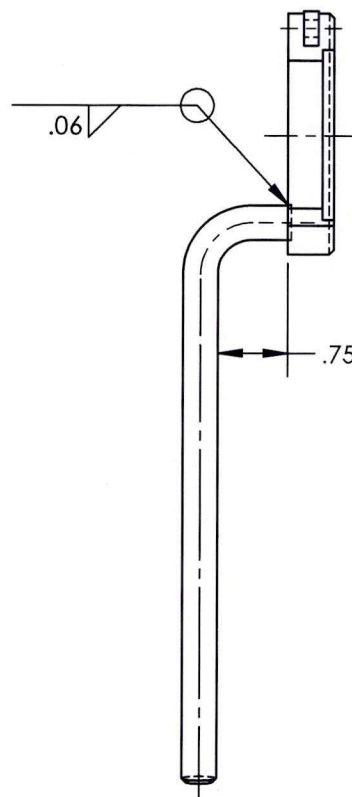
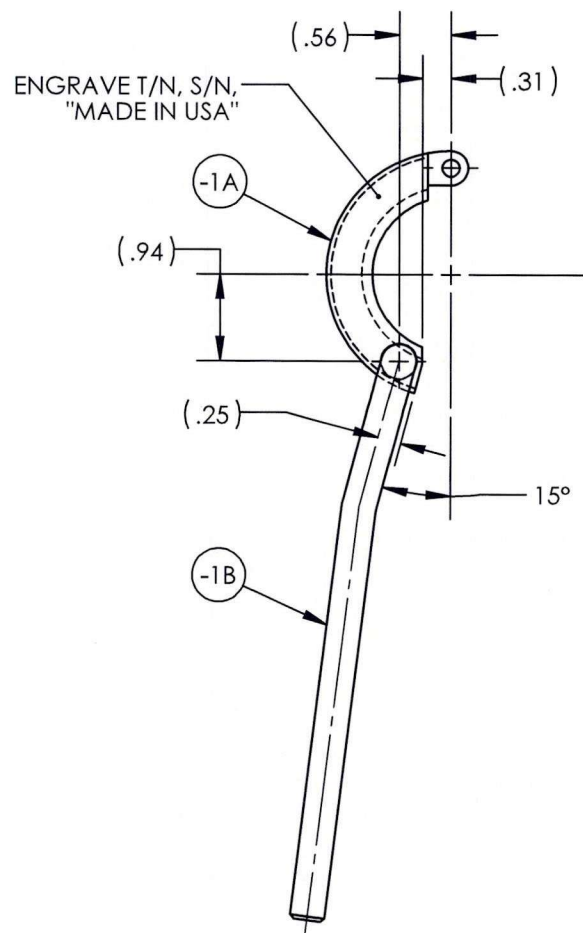
Part Specifications

Specifications could not be found.

Plex 5/14/19 4:53 PM Dart.Renwick.Jennifer

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA".	4/27/2017	DPD	JAG



URF 19-752 19.05.30 (VM)

(-1)

JAW

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-1	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .010 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .02 ANGLES ± 1°
DRAWN BY: DD 04/27/2017	.X ± .1 SURFACES = 125/✓
CHECKED: RJC 05/02/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 05/05/2017	.015 x 45° OR .016R
QA APPR: JL 05/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: JAG 05/18/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 4/27/2017	250 SERIES
SHEET 2 OF 8	

Under Review Notification

Raised By: VANESSA MOREL

Date: 19.05.30

Product #: Dart Tooling ROLLS ROYCE

Product Name: COMPRESSOR IMPELLER ASSEMBLY

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN / URF Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		DO NOT SHIP	Red Tag/Quarantine Stock	Advise Customers	Hold all Production	Re-Work Stock	IPP Under Review (Engineer Signoff Required.)	Put Product Specifications Under Review ("Bluefiles")		
RB6798927	RB6798927 REV 2	Y	Y	N	Y	N	N	N	19-752	All sub components must be placed under review as well

Description of Issue:

FIT ISSUE
DWG WILL BE UPDATE BY ENG.

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

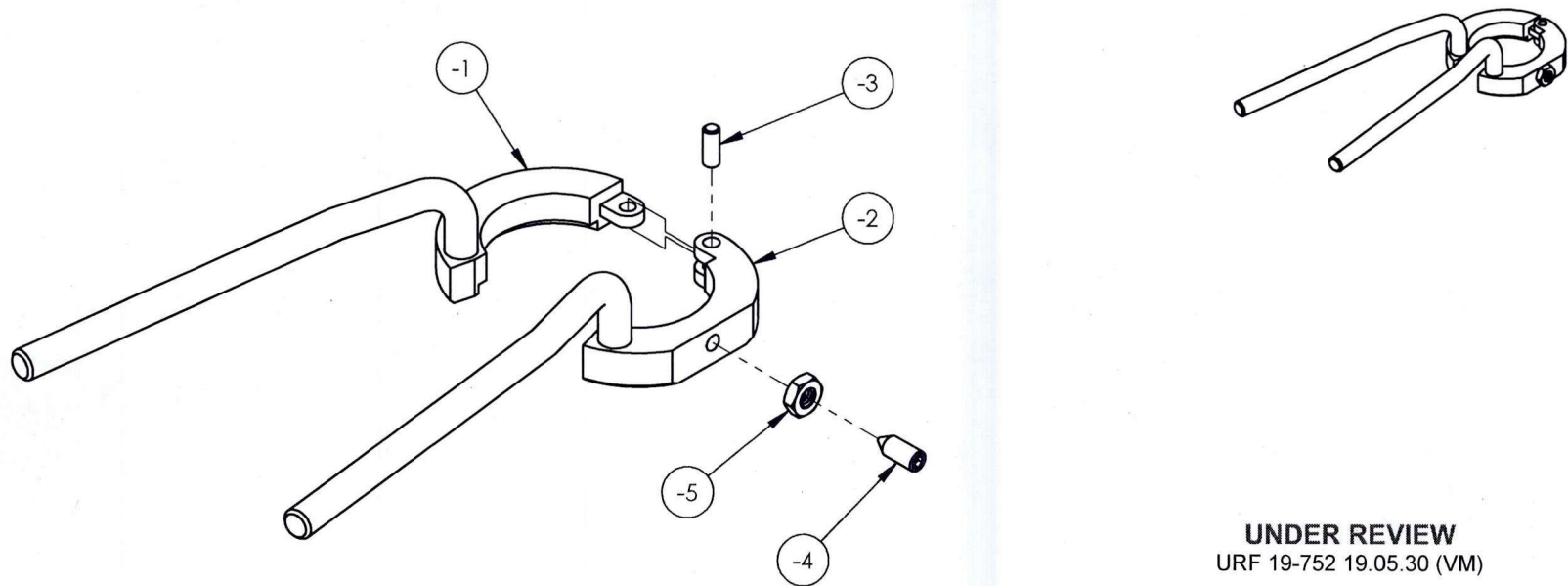
Supply Chain Director / Senior Buyer

Marketing Eugene

H:\Forms\Engineering\Approved ENG Online\URF revE.xls

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". -1A CH'D MAT'L WAS 4130 IS 4140/4142, ADDED DIMS Ø.385+-.005-.000, .040, .170+-.005, CH'D DIMS WAS Ø.187 PRESS FIT FOR PIN IS Ø.1869-.1874 THRU ALL (P.F. -3), WAS .160 SLIP FIT CENTRAL FOR ITEM -2A IS .160 +.000-.005 (S.F. -2A). -1B CH'D MAT'L WAS 4130 IS 4140/4142, DELETED HEAT TREAT RC 32-36, ADDED DIMS .790, (.978), Ø.375+-.005, .060. -2 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. -2A CH'D MAT'L WAS 4130 IS 4140/4142, ADDED DIMS Ø.385+-.005-.000, .040, .169+-.005, CH'D DIMS WAS Ø.187 SLIP FIT FOR PIN IS Ø.1902-.1890 THRU ALL (S.F. -3), WAS .160 SLIP FIT CENTRAL FOR ITEM -1A IS .162 +.000-.005 (S.F. -1A). -3 ADDED B/O REF (#98381A314). -4 ADDED B/O REF (#9269SA307) MODIFIED, CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. -5 ADDED B/O REF (#94846A029).	4/27/2017	DPD	JAG



UNDER REVIEW
URF 19-752 19.05.30 (VM)

NOTE:
REF. ROLLS ROYCE T/N: 6798927.

DART AEROSPACE																					
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT																					
DWG NO. RB6798927	REV 2																				
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XX ± .010 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .02 ANGLES ± 1°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td colspan="2">2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td colspan="2">USED ON MODEL</td> </tr> <tr> <td colspan="2">250 SERIES</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XX ± .010 FRACTIONS ± 1/8	SPEC	.XX ± .02 ANGLES ± 1°		.X ± .1 SURFACES = 125/	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		USED ON MODEL		250 SERIES	
MAT'L	UNLESS OTHERWISE SPECIFIED																				
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250 SERIES																					
DRAWN BY: DD 04/27/2017	QA APPR: AA 05/05/2017																				
CHECKED: RJC 05/02/2017	QA APPR: JL 05/10/2017																				
OPPS APPR: AA 05/05/2017	APPROVED: JAG 05/18/2017																				
SCALE 1:2	DATE 4/27/2017																				
SHEET 1 OF 8																					

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	JAW			2
	1		-1A		JAW PART	4140/4142		3
	1		-1B		JAW PART	4140/4142		4
X			-2	1	CRIMPER JAW			5
1			-2A		JAW PART	4140/4142		6
1			-2B		JAW PART	4140/4142		7
		B/O	-3	1	DOWEL	STEEL	Ø3/16 X 1/2 (MCMASTER-CARR #98381A314)	1
			-4	1	CONE POINT SET SCREW	STEEL	1/4-20 X 3/4 (MCMASTER-CARR #9269SA307) MODIFIED	8
		B/O	-5	1	HEX JAM NUT	STEEL	1/4-20, GRADE 5 (MCMASTER-CARR #94846A029)	1
ASSY -2	ASSY -1							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043647



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043647

PO Date: 6/5/19

Due Date: 6/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-06

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195146	RB6798927-1	Jaw Weldment Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54
2	195147	RB6798927-2	Crimper Jaw Weldment Outside Processing - Black Oxide -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54

Plex 6/6/19 9:43 AM Dart.Guerin.Kimberley



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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043647



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191523	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	7 pcs	0 pcs	7 pcs	\$3.636/pcs	\$25.45
				X7		JUN 11 2019				DF	
4	194416	RBST2162-11	Primary Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	13 pcs	0 pcs	13 pcs	\$3.636/pcs	\$47.27
				X13		JUN 11 2019				DF	
5	194270	RBE350A93-3201-00-23	Sleeve -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	6/12/19	5 pcs	0 pcs	5 pcs	\$3.636/pcs	\$18.18
Grand Total:											\$119.99

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Handwritten signature]
6-6-19

Plex 6/6/19 9:43 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(019787-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

019787- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Jun-2019		SVETLANA DORZHIYEVA		POHB043647				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6798927-1 Rev.	RB6798927-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0	0	0
2	RB679827-2 Rev. RB6798927-2	RB679827-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0	0	0
3	RBE-350DAMPER Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0
4	RBST2162-11 Rev.	RBST2162-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	13	13	0	0	0
RECEIVED JUN 11 2019 DART AEROSPACE LTD.								

DAS
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9-89

RECEIVED
 JUN 11 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.